

Work Order ID 60761

Thursday, July 22, 2010 10:51:58 AM



Page 1

Item ID: D3574-6

Accept



Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



Start Date: 7/22/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 7/29/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-7-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr Revision Nbr

D3574 Rev B

100



FLOW WATER JET

0.00

B 10-7-22

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

(3)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

B 10-7-22

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

S (10-7-22)

(T3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Small Fab

Small Fab

Operation
Description

Small Fab

Memo

Deburr if necessary.

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. wuthue

(13)

150



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

PP 60760

10-7-27 SPX

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Page 3

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/2010

(10-7-27)
(3)

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Picklist Print

Thursday, July 22, 2010 10:52:02 AM

Page 1

Work Order ID: 60761



Parent Item: D3574-6



Parent Item Name: Cabin Floor Protector

Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No				sf	3,321.706	33.6	100.8504			RB10-7-22

Location	Loc Qty	Loc Code
MAT	3321.7068	
111710	10	
112585	155.783	
114032	467.9238	
115261	2688	115261

(3)

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DART AEROSPACE LTD	Work Order:	20761
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.007	X	RD	T	MB01
7.37	+/-0.030	7.37	X		T	
11.00	+/-0.030	11.00	X		T	
15.25	+/-0.030	15.25	X		T	
25.87	+/-0.030	25.87	X		T	
39.75	+/-0.030	39.75	X		T	
44.75	+/-0.030	44.75	X		T	
58.38	+/-0.030	58.38	X		T	
63.50	+/-0.030	63.50	X		T	
65.25	+/-0.030	65.25	X		T	
10.25	+/-0.030	10.25	X		T	
11.87	+/-0.030	11.87	X		T	
14.75	+/-0.030	14.75	X		T	
26.00	+/-0.030	26.00	X		T	
40.87	+/-0.030	40.87	X		T	
45.00	+/-0.030	45.00	X		T	
48.00	+/-0.030	48.00	X		T	
55.13	+/-0.030	55.13	X		T	
61.25	+/-0.030	61.25	X		T	
61.88	+/-0.030	61.88	X		T	
64.63	+/-0.030	64.63	X		T	
1.13	+/-0.030	1.18	X		T	
7.63	+/-0.030	7.63	X		T	
11.00	+/-0.030	11.00	X		T	
22.10	+/-0.030	22.10	X		T	
22.50	+/-0.030	22.50	X		T	
24.50	+/-0.030	24.50	X		T	
35.13	+/-0.030	35.13	X		T	
36.50	+/-0.030	36.50	X		T	
40.00	+/-0.030	40.00	X		T	
41.88	+/-0.030	41.88	X		T	
43.63	+/-0.030	43.63	X		T	
6.75	+/-0.030	6.75	X		T	
9.50	+/-0.030	9.50	X		T	

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	60761
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

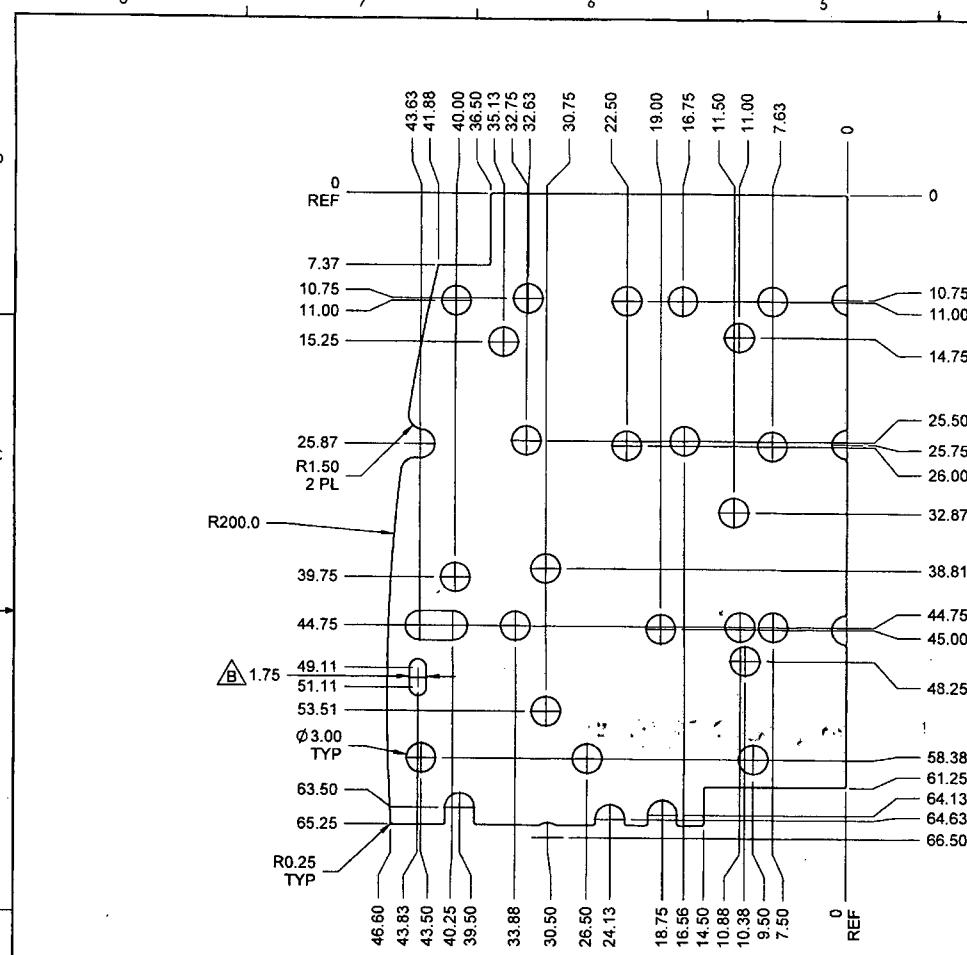
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.38	+/-0.030	10.38	*		T	RB01
14.50	+/-0.030	14.50	*		T	
16.75	+/-0.030	16.75	*		T	
18.94	+/-0.030	18.94	*		T	
19.00	+/-0.030	19.00	A		T	
24.13	+/-0.030	24.13	*		T	
33.88	+/-0.030	33.88	*		T	
39.50	+/-0.030	39.50	*		T	
40.25	+/-0.030	40.25	*		T	
43.50	+/-0.030	43.50	*		T	
46.60	+/-0.030	46.60	B		T	
0.125	+/-0.010	.125	*		T	

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	10-7-27	Date:	10/07/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ//DD	
B	09.05.15	Dimensions updated per Dwg Rev B	KJ	M

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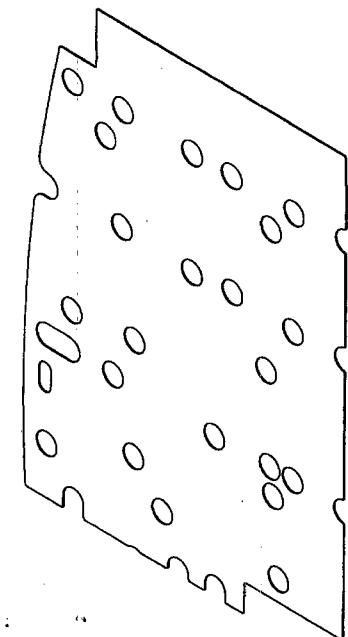


D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40761
PL 10-721



RELEASED
01/01/07 ADP

B	ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5, -2 NOW SHOWN ON SHEET 2	<i>AS</i>	08.03.25
A	NEW ISSUE	CB	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD		
DRAWN	HAWKESBURY, ONTARIO, CANADA		
CHECKED	DRAWING NO. <i>D3574</i>		
MFG. APPR.	REV. B SHEET 1 OF 6		
APPROVED	TITLE CABIN FLOOR PROTECTOR		
DE APPR.	SCALE NTS		
DATE	09.03.25		

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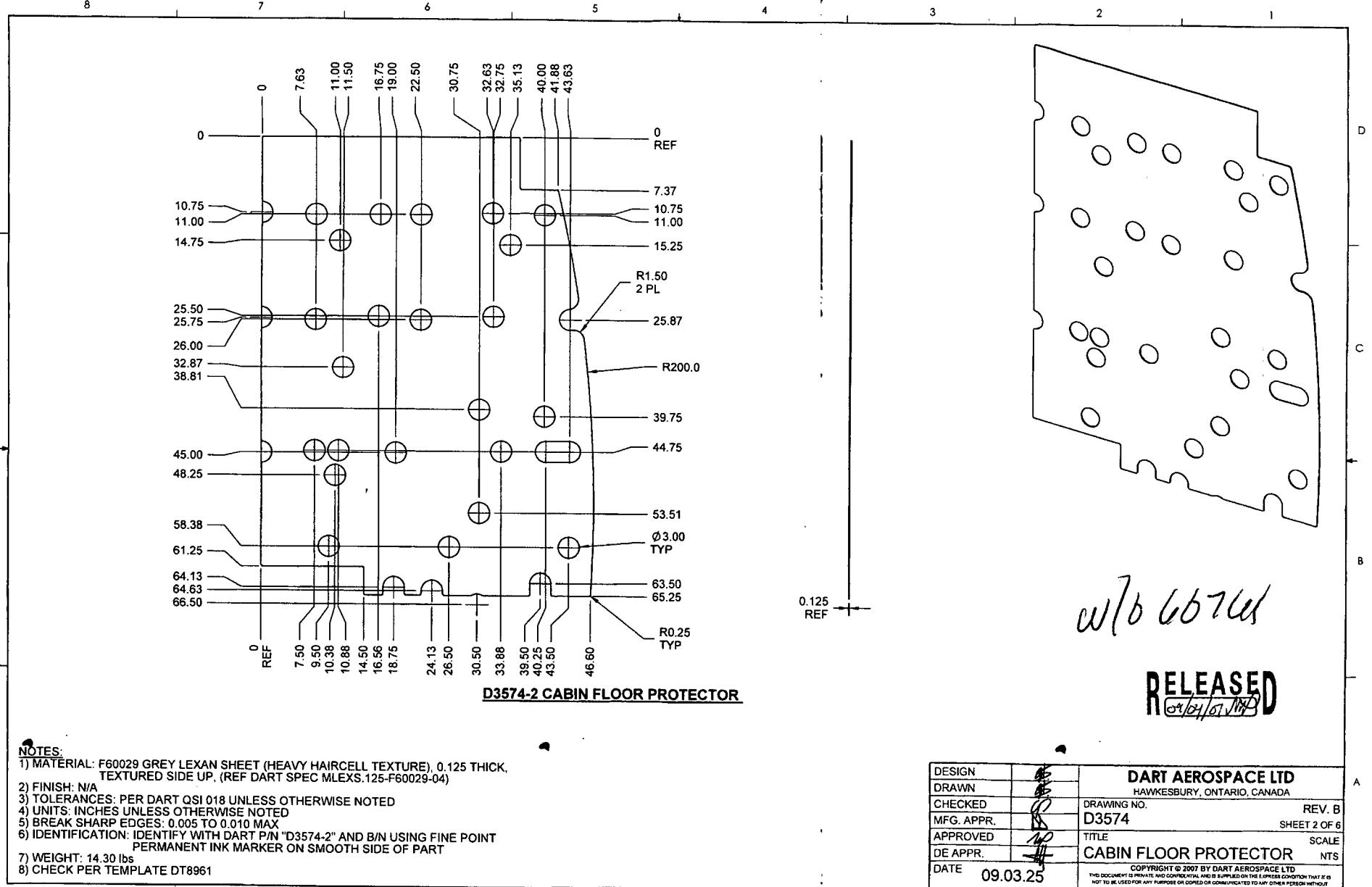
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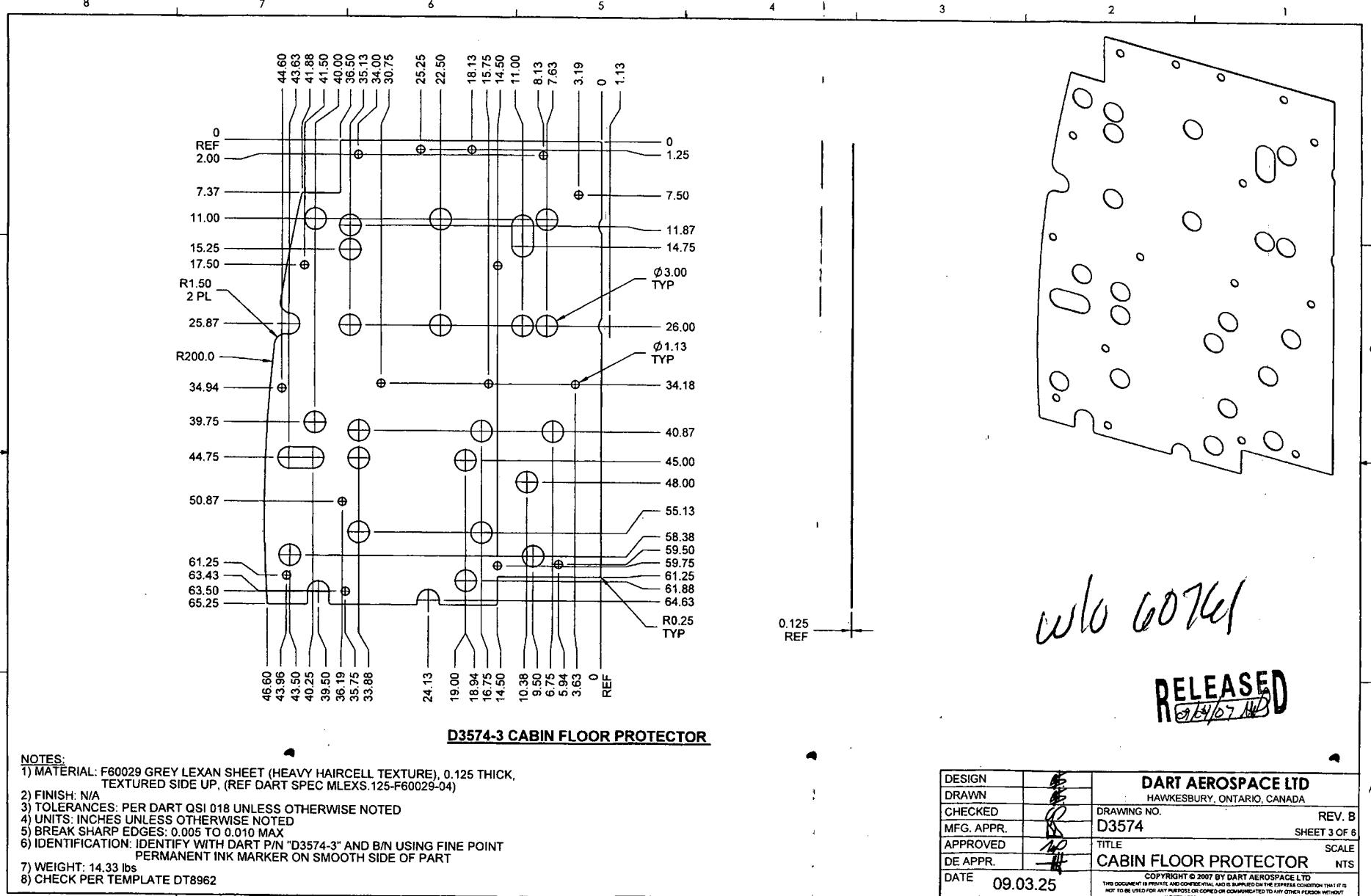
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CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	D3574
DE APPR.	<i>[Signature]</i>	SHEET 3 OF 6
DATE	09.03.25	TITLE
		CABIN FLOOR PROTECTOR
		NTS

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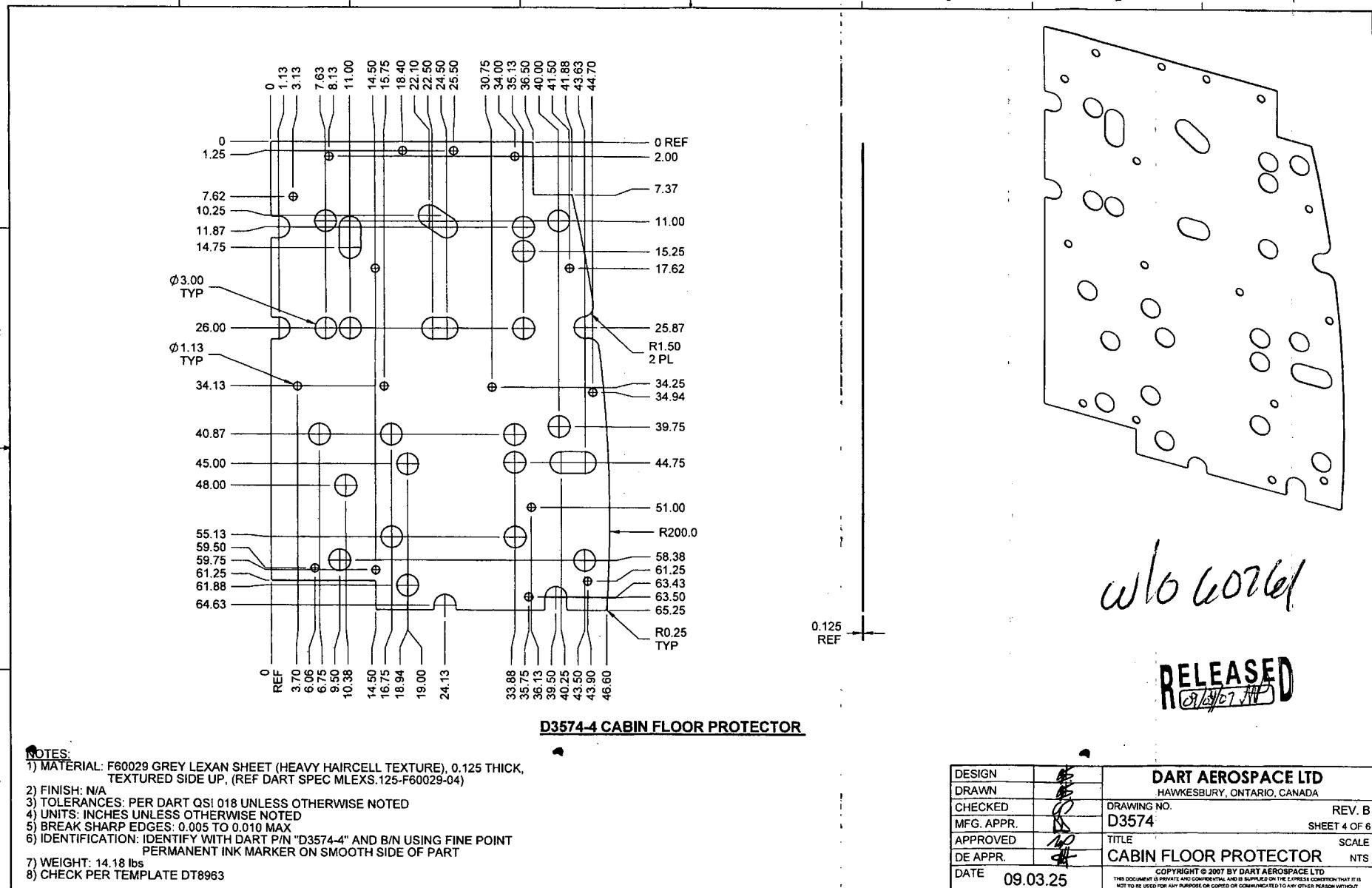
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CHECKED	<input checked="" type="checkbox"/>	DRAWING NO.			
MFG. APPR.	<input checked="" type="checkbox"/>	REV. B			
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SCALE					
NTS					

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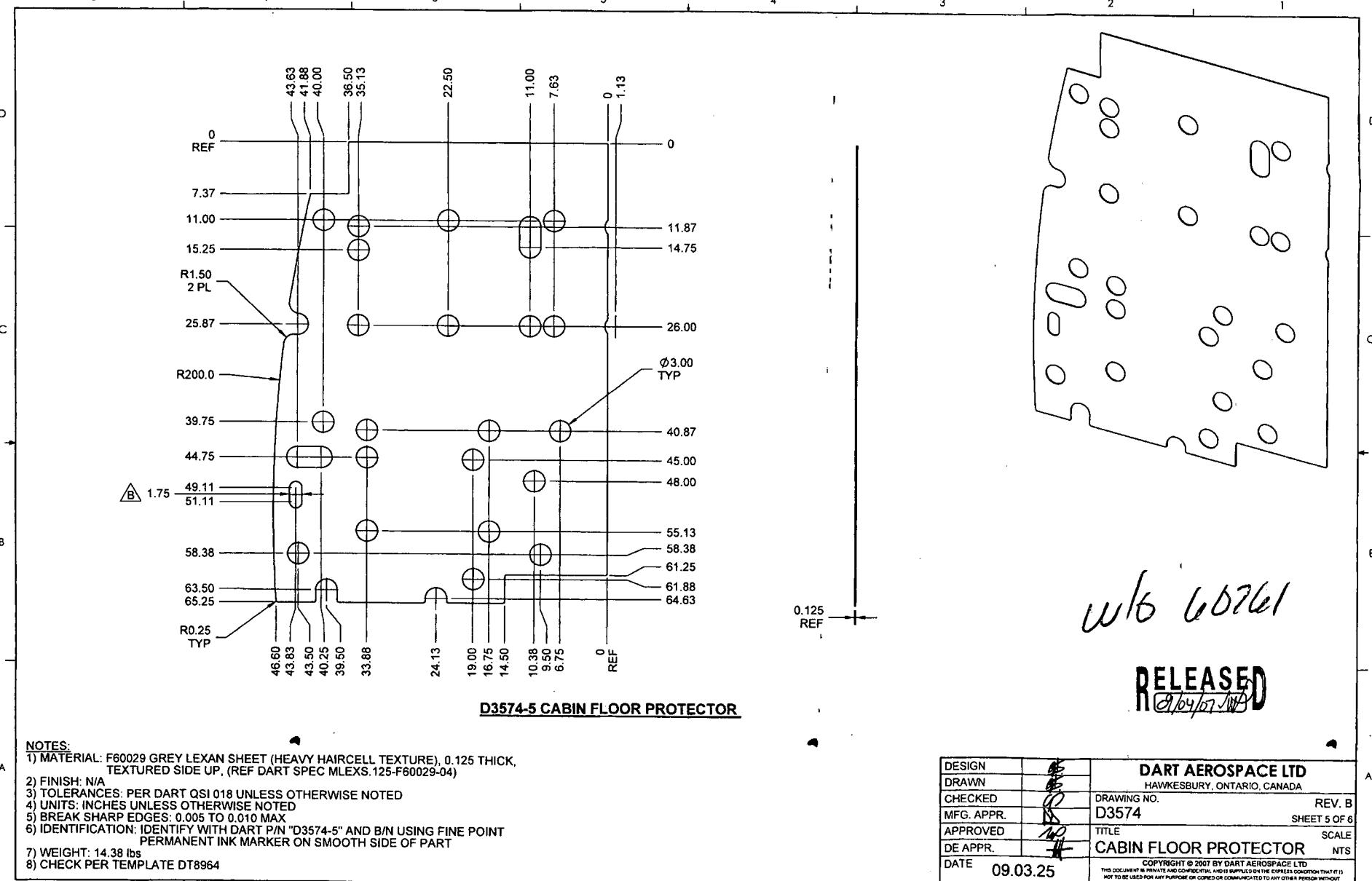
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CHECKED	<i>[Signature]</i>	DRAWING NO. REV. B
MFG. APPR.	<i>[Signature]</i>	D3574 SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE
DE APPR.	<i>[Signature]</i>	SCALE
DATE	09.03.25	CABIN FLOOR PROTECTOR NTS

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w/6 60761
RELEASED
01/04/07 JWD

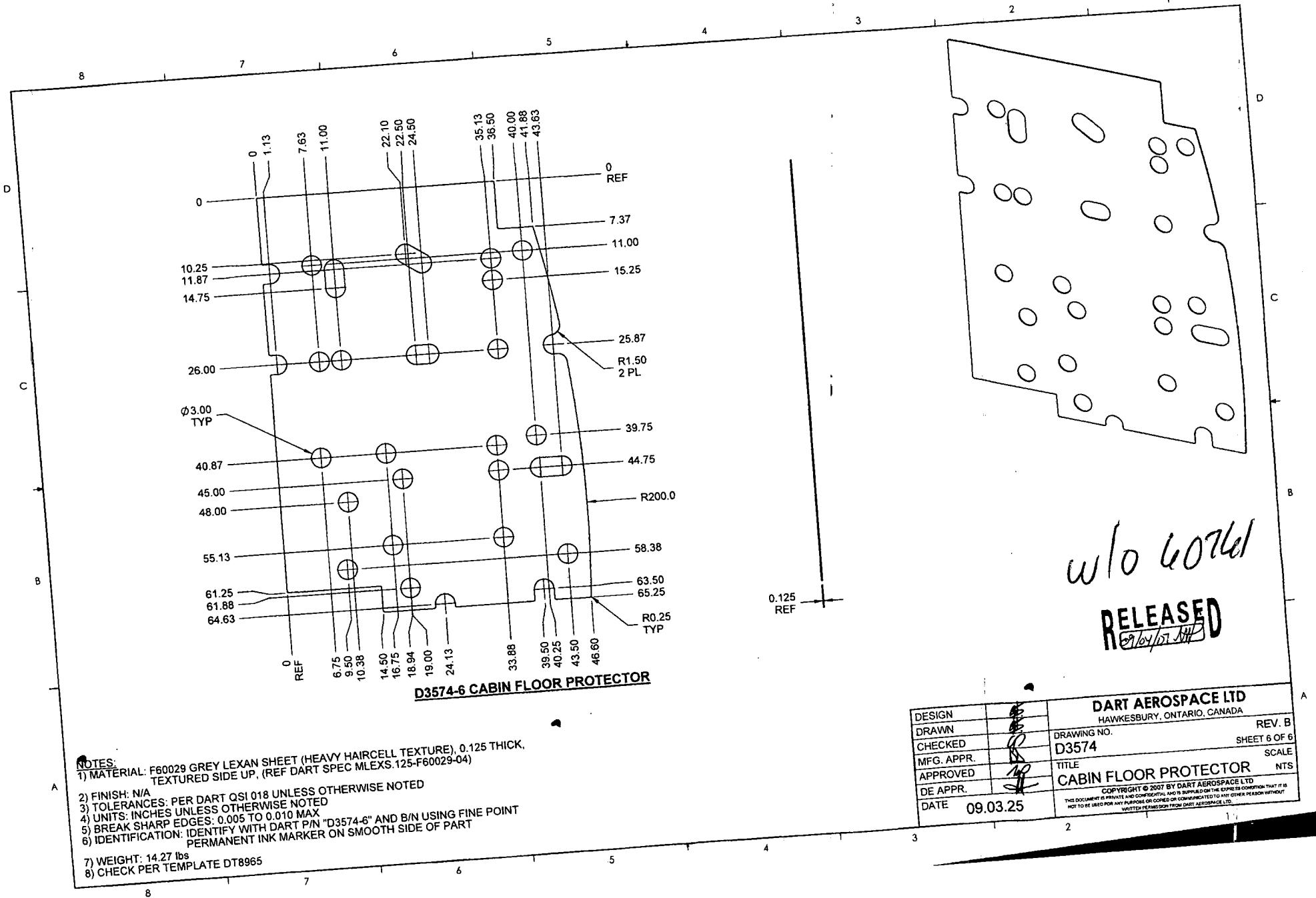
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MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE CABIN FLOOR PROTECTOR
DE APPR.	<i>[Signature]</i>	NTS
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